

Date: Monday, 04/06/2007 8:19:20 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 32747  
 Estimate Number : 11181  
 P.O. Number : N/A  
 This Issue : 04/06/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : SMALL /MED FAB  
 Previous Run : 32095

Drawing Name : BRACKET  
 Part Number : D32941  
 Drawing Number : D3294 REV A1  
 Project Number : N/A  
 Drawing Revision : A1  
 Material : N/A  
 Due Date : 11/06/2007

Qty: \*Um: Each

Written By :  
 Checked & Approved By :  
 Comment : Est A 04.08.24 New issue KJ/JLM  
 Est Rev:B Now On Waterjet 07-03-26 JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet
<p>Comment: Qty.: 2.1072 sf(s)/Unit Total : <del>10.000 sf(s)</del> 6.8580            Material: 2024-T3 (QQ-A-250/4) 0.080" thick            (M2024T3S.080)            Identify for D3294-1            Batch: ml 07 06 04</p>		
2.0	WATER JET	FLOW WATER JET
<p>Comment: FLOW WATER JET            1-Cut as per Dwg D3294            Dwg Rev: A1            Prog Rev: A1            2-Deburr if necessary</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK</p>		

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 04/06/2007 8:19:20 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32747

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 07/06/04 8

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3294

SB 07/06/04 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07.06.04 (8)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ell

07-06-05 (8)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m/02316

FZ

07/06/05 (8)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

m-A

07/06/05 (8X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/06/05 (8)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05 (8)

Job Completion



07-06-05 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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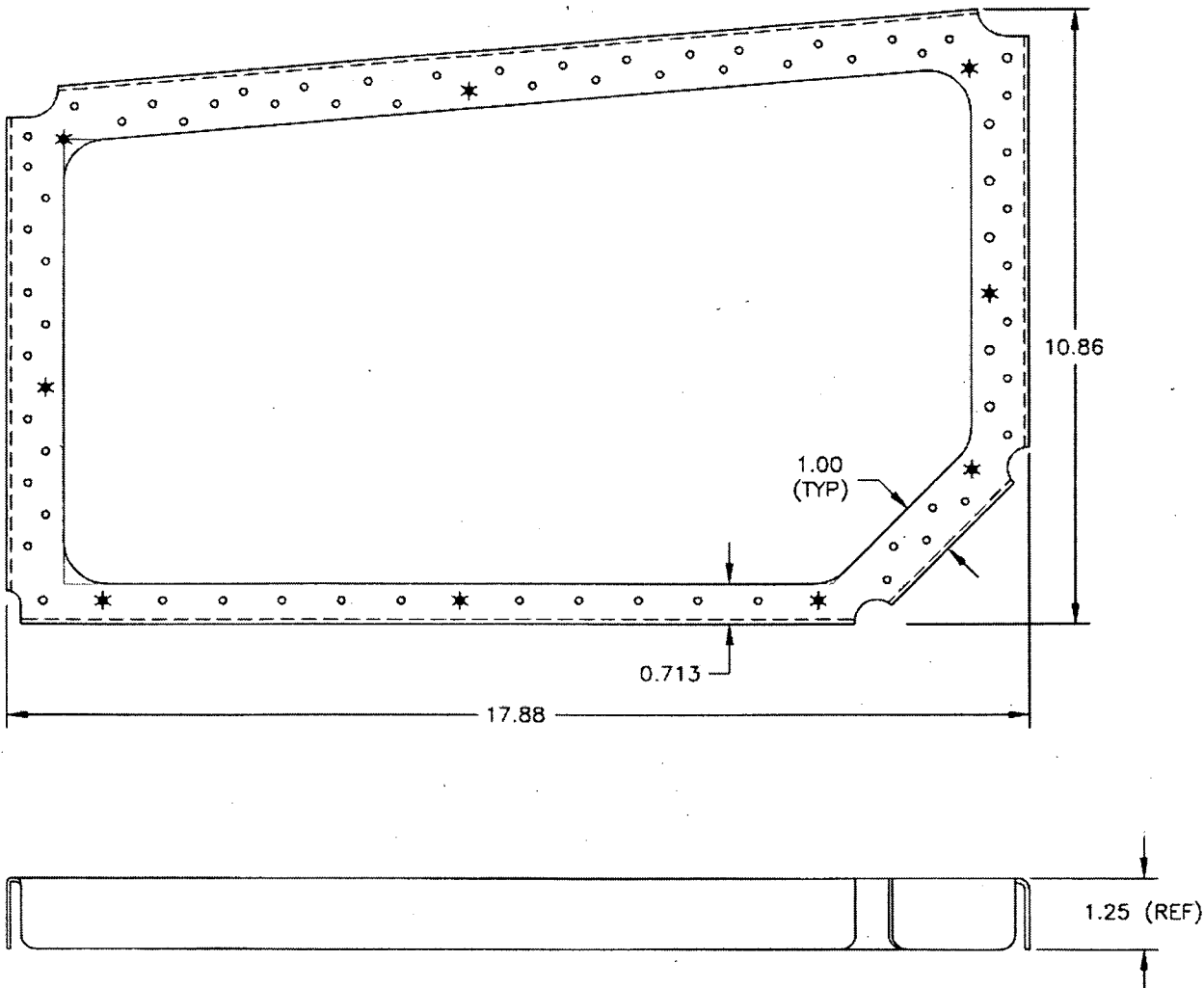
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. A
		D3294	SHEET 1 OF 2
DATE		TITLE	SCALE
04.06.28		BRACKET	1:3
A	04.06.28	NEW ISSUE	
AI	05.06.13	12.97 WAS 13.23, AS MANUFACTURED	

**RELEASED**  
04.07.12**D3294-1 BRACKET**

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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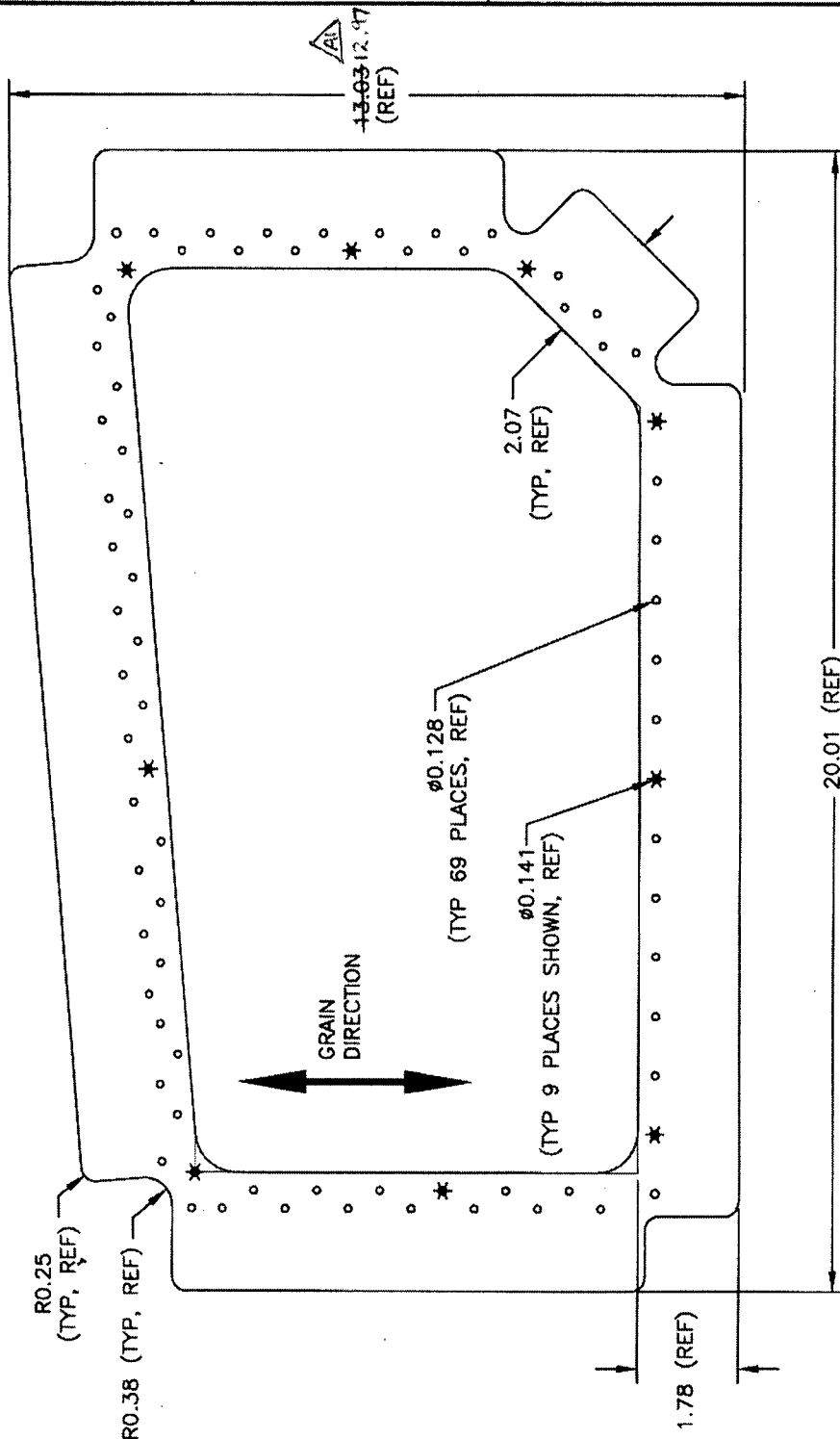
**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3294	REV. A SHEET 2 OF 2
DATE 04.06.28		TITLE BRACKET	SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED  
04.07.12



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 32747
Description: Bracket		Part Number: D3294-1
Inspection Dwg: D3294	Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\varnothing 0.141$	+0.005-0.001	0.142	✓		VERN	
B $\varnothing 0.128$	+0.005-0.001	0.130	✓		VERN	
C 12.97	+/-0.030	12.97	✓		M.T	
D 20.01	+/-0.030	20.01	✓		M.T	
E 1.78	+/-0.030	1.783	✓		VERN	
F 2.07	+/-0.030	2.071	✓		VERN	
G R0.25	+/-0.030	R0.25	✓		R.G	
H R0.38	+/-0.030	R0.38	✓		R.G	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM</i>	Audited by: <i>Er</i>	Prototype Approval:	N/A
Date: 07/06/04	Date: 07/06/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	